#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-018308 Address: 333 Burma Road **Date Inspected:** 27-Nov-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes An Qing Xiang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG COMPONENT** 

#### **Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 11DE to 11EE, UT repair weld No.OBW11C-009. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as CWR2286.

SMAW in the 4G position for the OBG segment 11DE, UT repair weld No.CA90-002. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR17820.

SMAW in the 4G position for the OBG segment 11EE, UT repair weld No.CA94-006. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair report is identified as WR17820.

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SMAW in the 1G position for the OBG segment 11EE, UT repair weld No.SEG074A-014. The welder is identified as #050289. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The repair report is identified as WR17823.

SMAW in the 1G position for the OBG segment 11DE, UT repair weld No.SEG072A-044. The welder is identified as #050289. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The repair report is identified as WR17823.

Ultrasonic Testing (UT) for Segment 11CW to 11DW

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG segment 11CW to 11DW splice weld joints.

The welds designation reviewed are as follows:

SP783-001-050

SP743-001-050

SP505-001-057

BP107-001-028

BP053-001-028

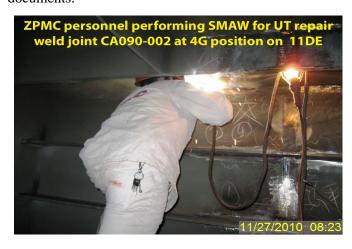
BP161-001-024

SP169-001-052

SP142-001-046

SP115-001-059

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



#### **Summary of Conversations:**

No relevant conversations

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# **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer